



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D3065-3

Job Sheet 180483



Part No: D3065-3

Job Qty: 60 ea

20
21
9-89

Part Name: Step Spacer



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/6/18

Job Tracking No:

Due Date: 8/3/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP: C 02.11.01 Incorporated D3066-1 IPP KJ/RF IPP Rev:D Now on Water Jet 06-04-11 JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	60 Ea		8/3/18	0.00	0.00	Start Up Waterjet		SC 18-07-12
100	Waterjet	60 pcs		8/3/18	0.00	2.76	Waterjet1		SC 18-07-12
120	QC	60 pcs		8/3/18	0.00	0.00	QC8		38
140	Brake NC	60 pcs		8/3/18	0.02	2.82	Brake NC 1		1-89
150	QC	60 pcs		8/3/18	0.00	0.00	QC5		PD 18-07-31
160	HandFinish	60 pcs		8/3/18	0.00	1.23	HandFinish1		SA 18-08-01
170	QC	60 pcs		8/3/18	0.00	0.00	QC7-1		PD 18-08-02
180	Packaging	60 pcs		8/3/18	0.00	0.00	Packaging3-1		1/26
190	QC21-SA	60 Ea		8/3/18	0.00	0.00	QC21		21 AUG 14 2018

Part Op 100 - 1-Cut as per Dwg Rev: 1

Descriptions: 140 - Bend as per Dwg D3065

180 - LOCATION : GA

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.040	2024-T3 .040 Sheet	13.0680 sf (.2178 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M2024T3S.040	13	119	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Step Spacer	1.260inches ± 0.010	1.270 1.250	1,258	
2	Step Spacer	3.260inches ± 0.010	3.270 3.250	3,257	
3	Step Spacer	5.260inches ± 0.010	5.270 5.250	5,261	
4	Step Spacer	6.520inches ± 0.010	6.530 6.510	6,518	
5	Step Spacer	2.093inches ± 0.010	2.103 2.083	2,091	

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____		MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7 CANADA TEL.: 1 613 832-8200 Email: sales@dartaero.com www.dartaerospace.com Date: 07/17/18 Container No: S092870 Part: D3065-3 Job No: 180483 Serial No/Batch: S092870 Revision: _____ Inspector: _____ Exp Date: _____ Instructions: _____		Disposition					
		Enviro Do Equip Handling/Pre Material Internal Transport Tribal Knowledge LOA Substation Past Expiry Date Misidentified		Training Use for Testing Poor Information Rushing Product Improvement Process Improvement Manufacturing Process Past Due Crimp/Kink/Ripple/wave Cuffs Crushing Heat Treat Wave/Twist in Tube Marks/Chatter			
		OTHER :					

6	Step Spacer	3.936inches ± 0.010	3.946 3.926	3,935
7	Step Spacer	4.186inches ± 0.010	4.196 4.176	4,189
8	Step Spacer	0.129inches + 0.005 - 0.000	0.134 0.129	0,129
9	Step Spacer	1.250inches + 0.005 - 0.000	1.255 1.250	1,250
10	Step Spacer	1.204inches ± 0.005	1.209 1.199	1,201
11	Step Spacer	0.040inches ± 0.010	0.050 0.030	0,040

Plex 7/6/18 1:34 PM Dart.lajeunesse.marie

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition			
				Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					